

Date: Wednesday, 9/26/2007 2:07:25 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 6" MIRROR
Job Number	: 34886		
Estimate Number	: 10101		
P.O. Number	: <i>N/A</i>	Part Number	: D2011101
This Issue	: 9/26/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2011 REV. F
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 33916	Drawing Revision	: F
	Type : SMALL /MED FAB	Material	: <i>N/A</i>
Written By	:	Due Date	: 10/5/2007
Checked & Approved By	:	Qty:	30 Um: Each
Comment	: Est: J 04.09.15 Added Steps 5-7 KJ/JLM		
	: Est: K 05.12.15 chg black sikaflex for white EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *4693*
Purchase Grote Mirror P/N: 28043
Possible supplier: UAP/NAPA
Material release note required

CZ 7/10/26
(30)

2.0	28043	MIRROR 6"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)
Mirror 6"

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage
Ensure Material Release Note is attached

07/10/02
(30)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

07/10/05
(30)
comp

5.0	D30141	Locknut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)
Locknut

Pick:

Qty	Part Number	Description	Batch
1	D3014-1	Lock nut	<i>B25021</i>

SAD 07-10-07
(30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 21/01/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/26/2007 2:07:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 6" MIRROR

Job Number: 34886

Part Number: D2011101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960JD416L

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD416L Washer

4105408

SAD 07-10-07

(30)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Discard Hardware & Install new hardware loosely

SAD 07-10-07

30

2- Drill mirror using drill Jig DT8704 as per Dwg D2011

SAD 07-10-07

30

3- Inject 3ml of Sikaflex -291/-241 adhesive per hole.

Qty Part Number Description Batch

9ml N/A Sikaflex-291/-241

4105488

Expiry date

07/2008

Start: 07/10/11 Time: 6:00

Finish: 07/10/11 Time: 8:00

SAD 07-10-11

(30)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4- Test assembly to 50lbs pull test after 24 hours

SAD 07-10-26 (30)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57228

07/10/28

30

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SAD 07-10-30

Job Completion



07-10-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector





Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

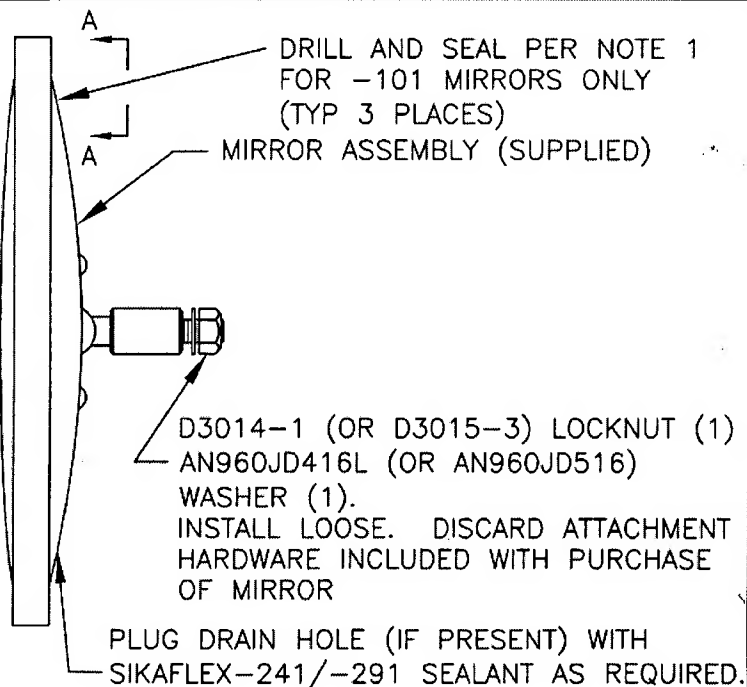
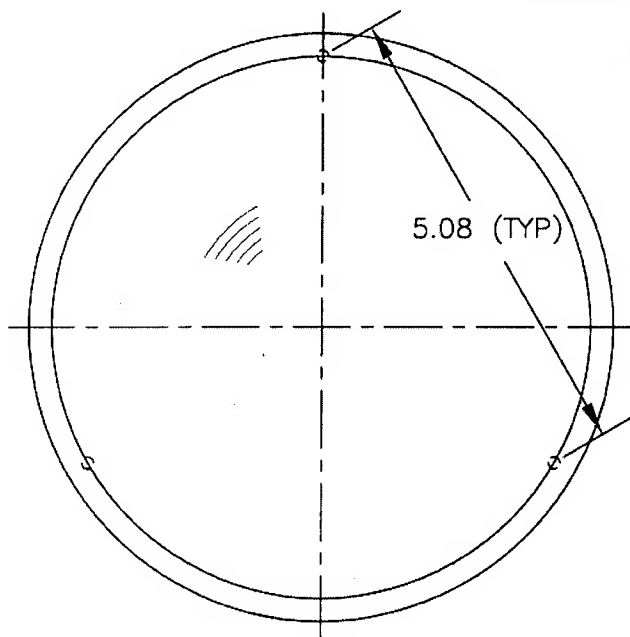
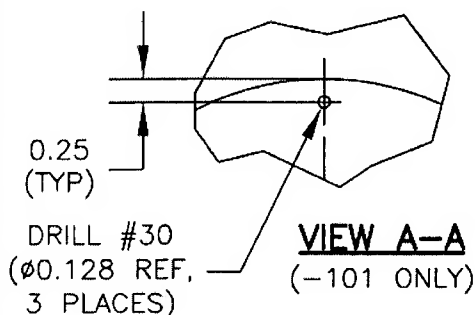
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. REV. F D2011 SHEET 1 OF 1	
DATE 04.09.10				TITLE SCALE MIRROR ASSEMBLY 1:2	
—	90.03.31		NEW ISSUE		
A	90.06.15		DWG No. WAS DSP1011, ADDED —103		
B	98.04.09		SIKAFLEX 241 ADDED		
C	99.06.01		REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN		
D	01.04.23		NEW 6" MIRROR, ADD NUT, RMV STUD		
E	01.05.08		NEW 8" MIRROR		
F	04.09.10		ADD HOLES FOR SEALANT ON —101		



RELEASED
04.09.10

QTY -101	QTY -103	Part Number	Description
X		D2011-101	MIRROR ASSEMBLY 6"
	X	D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
1		AN960JD416L	WASHER
	1	D3015-3	LOCKNUT
	1	AN960JD516	WASHER

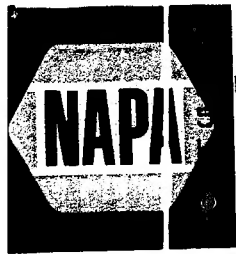
NOTES:

- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34886

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WILKESBURY AUTO PARTS INC 5580GST#:
4 MAIN STREET WEST
WILKESBURY, ONT. K6A 2J2
TEL: 632-8575 FAX: 632-1539

861597896RT0001

DANGEROUS GOODS PERMIT
EXPIRY DATE:

EMERGENCY TELEPHONE NUMBER 24 HOURS
CANUTEC 613-996-6666

CCT #	SOLD TO	DATE	TIME	STORE #	EMP #	INVOICE NO.
1601	DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	10/01/07	16:28	060004074	21	175930
SR #		PURCHASE ORDER #				ATTENTION
40		00004693				
AD		TAX EXEMPTION: 6122-5207				
1		TERMS: NET 30 DAYS				CHARGE SALE
		DELIVERY:				
PART NUMBER	LN	DESCRIPTION	QUANTITY	PRICE	NET	TOTAL
8043	GRD	GROTE	30.00	41.140	16.820	504.60 T150
B/O						
		<i>[Signature]</i>				
		<i>[Signature]</i>				
REFUNDED BY <i>[Signature]</i>		Subtotal				504.60
		Tax 6% GST ONLY				30.28
VERIFIED BY _____		Tax 0%				0.00

TOTAL ----> CHARGE SALE 534.88

SIGNATURE
ALL GOODS RETURNED MUST BE ACCOMPANIED BY THIS INVOICE